Quality Control





Page 1

D3537-1 Item ID: Accept Setup Start Revision ID: Stop Item Name: Wearpad Start Date: 6/20/2011 Start Oty: 50.00 Cust Item ID: Req'd Qty: 50.00 Required Date: 6/23/2011 Customer: Reference: Run Start Date: // 0/220 Tooling: Approvals: Process Plan: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Reject Accept Insp. Work Center ID Description Qty Qty Number Stamp Run Hours Code **Draw Nbr** Revision Nbr D3537 Rev C 100 0.00 FLOW WATER JET B 11-6-22 Waterjet 0.00 Memo 1-Cut as per Dwg D3537 Dwg Rev: Prog Rev: 2-Deburr FLOW CNC Waterjet 304,063 if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 B11-6-22 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 8 WO6/22 OC Memo

Dart	Aeros	pace	Ltd
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Dart Ae	rospace	Ltd						
W/O:			WO	RK ORDER CHANGES	3	4-12		
DATE	STEP	PRO	CEDURE CHAN	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 70972

Monday, June 20, 2011 2:45:07 PM



Page 2

Item ID:

D3537-1

Accept



Setup Start



Revision ID:

Item Name:

Wearpad

6/20/2011

Start Qty: 50.00

Req'd Qty: 50.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop

Required Date: 6/23/2011

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Tool#

Plan

Code

Accept

60

Qty

Reject

Oty

Reject Insp.

Number

Stamp

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation

NC BRAKE

Description

Run Hours 0.00

0.00 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-

Identify as D3537-1

140

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Oty Description Batch A/R 2059B Hardcoat

1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any

weld that penetrated through Wearpadif necessary

150

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Part No:PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) Date: Description of NC Corrective Action Section B Verification Approval Approval Approval Approval Approval Approval Approval										
Part No:	W/O:			WO	RK ORDER CHANG	ES				
Resolution:	DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Chief Eng /	Approval QC Inspector
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Work Order ID 70972

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Page 3

Item ID:

D3537-1

Accept

Setup Start



Revision ID:

Item Name:

Wearpad

Start Date:

6/20/2011

Start Oty: 50.00

Req'd Qty: 50.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Stop

Required Date: 6/23/2011

QC:

Date:

SPC (Y/N):

Date:

Run

Stop

Sequence ID/ Work Center ID

160

170

Quality Control

Powdercoat

Powder Coating

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

OVEN TEMPERATURE:

12 0 BR 11-7-25.

180

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	ES		_ BH		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Proc Mgr	Approval QC Inspector
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Work Order ID 70972

Monday, June 20, 2011 2:45:07 PM



Page 4

Item ID:

D3537-1

Accept



Setup Start

Stop



Revision ID:

Item Name:

Wearpad

Start Date:

Required Date: 6/23/2011

6/20/2011

Start Qty: 50.00

Req'd Qty: 50.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: (-(2)7

Memo



0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANG	ES		T		5
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

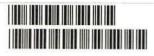
Monday, June 20, 2011 2:45:14 PM

Work Order ID: 70972

Parent Item:

D3537-1

Parent Item Name: Wearpad



Start Date: 6/20/2011

Required Date: 6/23/2011

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	30.2000	0.106	5.578947	6.5		
204/316 Shart 063										1B11-	6-27		

304/316 Sheet .063

Location	Loc Oty	Loc Code
MAT020	30.2	
117275	2.3	
117653	27.9	



117653

Dart Aerospace L	.ta
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W/O:			WO	RK ORDER CHANG	ES	Marca Cont	3	
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DART AEROSPACE LTD	Work Order:	70912
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

х	First Article	Prototype

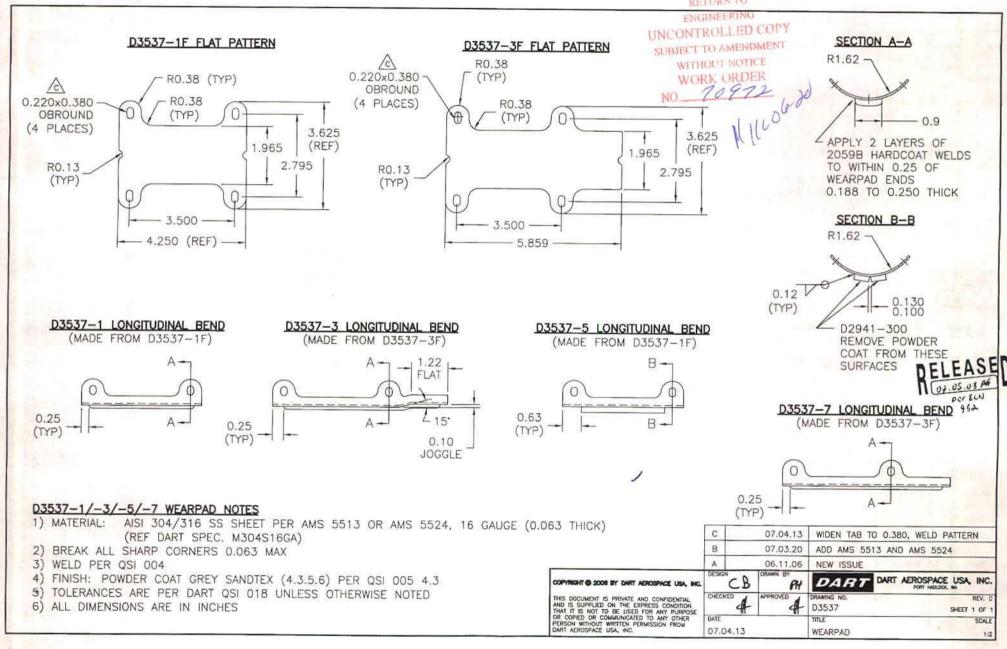
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2.795	+/-0.010	5.797	7		V	
3.625	+/-0.010	3.605	+		V	
0.220 x 0.380	+/-0.010	18E, X 16G.	>		V	

Measured by:		Audited by:	8	Prototype Approval:	N/A	
Date:	11-6-32	Date:	11/04/77	Date:	N/A	

Date	Change	Revised by	Approved
07.03.21	New Issue	KJ/JLM	
07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM -X/L	adl
	07.03.21 07.04.27	07.03.21 New Issue 07.04.27 Dimensions revised per Dwg Rev. B	07.03.21 New Issue KJ/JLM 07.04.27 Dimensions revised per Dwg Rev. B KJ/JLM

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